

Date: Friday, 28/11/2008 2:53:59 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 EXTRUSION BENDING  
 Job Number : 43845  
 Estimate Number : 10311  
 P.O. Number :  
 This Issue : 28/11/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2620  
 Drawing Number : D2620 REV B  
 Project Number : N/A  
 Drawing Revision : B  
 First Issue : 1/1 Type : SKIDTUBES  
 Drawing Revision : B  
 Material :  
 Due Date : 20/12/2008 Qty: 20 Um: Each  
 Previous Run : 42769  
 Written By :  
 Checked & Approved By : JLD 08-12-01  
 Comment : Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26001160 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)  
 Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	34715

RT 08-12-02

2.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1  
 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A  
 and Folio Ft008  
 2- Cut Fwd end of tube as per Dwg D2620

RT 08-12-02

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/12/02 (12)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: Skid tube cell

RT 08-12-02

5.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/02 JLD

Job Completion



MFC 08-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

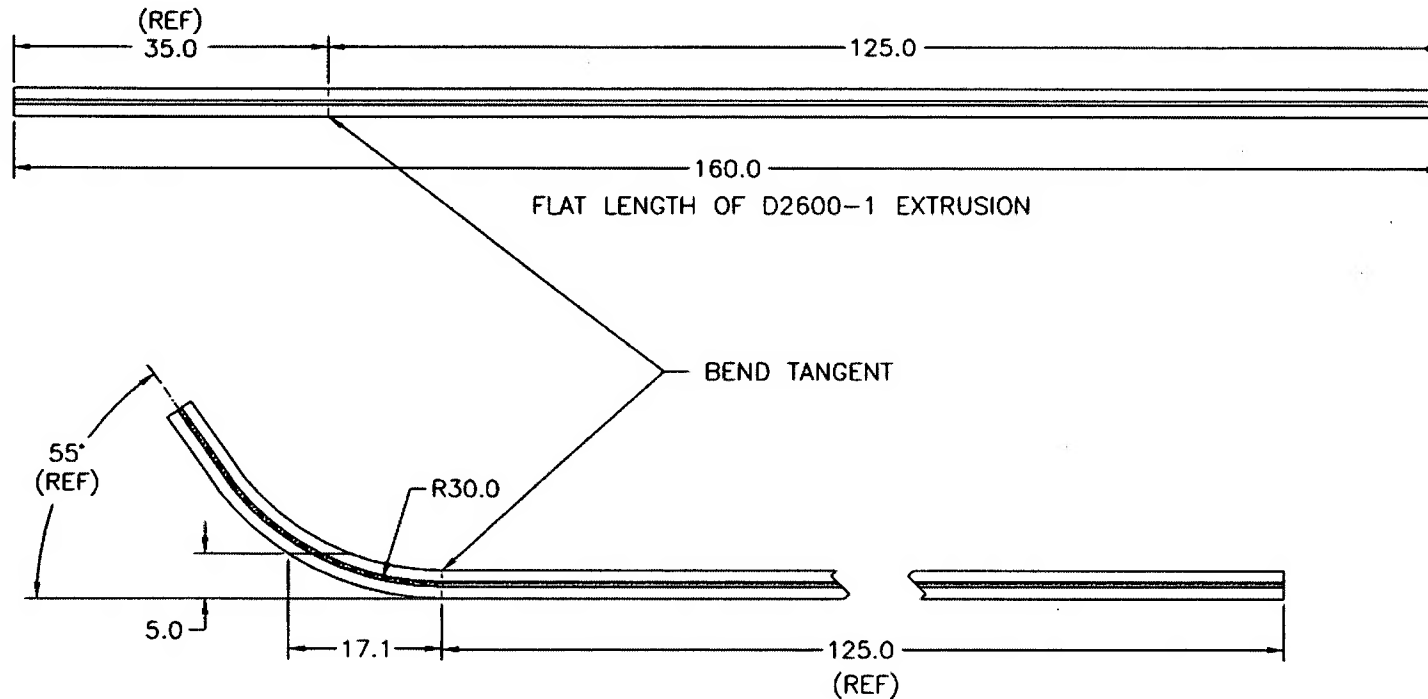
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING

**DART**



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE		REV. B
99.09.10		D2620
		206 SKIDTUBE BENDING CONTROL
		1:20
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING

**RELEASED**  
44.04.15 DS

WORK ORDER  
NO. 113845  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
ENGINEERING  
RETURN TO  
SHOP COPY